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**D2530****Job Sheet 192828****Part No:** D2530**Job Qty:** 12 pcs**Part Name:** Handle Weldment**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/2/19**Job Tracking No:****Due Date:** 4/26/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6 DD verf:EC**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation                     | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-------------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                               |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Large Fab - Welded Assy-1     | 12 pcs | 4/26/19    |          | 0.12      | 2.33    | Large Fab - 1         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 10        |           |          |
|       |                               |        |            |          |           |         | Large Fab - 2         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 3         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 4         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 5         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 6         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 7         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 8         |           |          |
|       |                               |        |            |          |           |         | Large Fab - 9         |           |          |
| 110   | QC 5                          | 12 pcs | 4/26/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 12             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 17             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 18             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 19             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 22             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 24             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 3              |           |          |
|       |                               |        |            |          |           |         | QC 5 - 43             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 49             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 51             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 58             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 68             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 9              |           |          |
|       |                               |        |            |          |           |         | QC 5 - 50             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 30             |           |          |
|       |                               |        |            |          |           |         | QC 5 - 40             |           |          |
| 120   | Large Fab - Welded Assy-2-B4B | 12 pcs | 4/26/19    |          | 0.00      | 4.80    | Large Fab - 1 - B4B   |           |          |
|       |                               |        |            |          |           |         | Large Fab - 10 - B4B  |           |          |
|       |                               |        |            |          |           |         | Large Fab - 2 - B4B   |           |          |
|       |                               |        |            |          |           |         | Large Fab - 3 - B4B   |           |          |

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|                                     |        |         |           |  |                       |        |
|-------------------------------------|--------|---------|-----------|--|-----------------------|--------|
|                                     |        |         |           |  | Large Fab - 4 - B4B   |        |
|                                     |        |         |           |  | Large Fab - 5 - B4B   |        |
|                                     |        |         |           |  | Large Fab - 6 - B4B   |        |
|                                     |        |         |           |  | Large Fab - 7 - B4B   |        |
|                                     |        |         |           |  | Large Fab - 8 - B4B   |        |
|                                     |        |         |           |  | Large Fab - 9 - B4B   |        |
|                                     |        |         |           |  |                       |        |
| 130 QC 9                            | 12 pcs | 4/26/19 | 0.00 0.00 |  | QC 9 - 10             |        |
|                                     |        |         |           |  | QC 9 - 18             |        |
|                                     |        |         |           |  | QC 9 - 24             |        |
|                                     |        |         |           |  | QC 9 - 43             | DAS 43 |
|                                     |        |         |           |  | QC 9 - 50             | 9-89   |
|                                     |        |         |           |  | QC 9 - 9              |        |
|                                     |        |         |           |  |                       |        |
| 140 QC 5                            | 12 pcs | 4/26/19 | 0.00 0.00 |  | QC 5 - 10             |        |
|                                     |        |         |           |  | QC 5 - 12             |        |
|                                     |        |         |           |  | QC 5 - 17             |        |
|                                     |        |         |           |  | QC 5 - 18             |        |
|                                     |        |         |           |  | QC 5 - 19             |        |
|                                     |        |         |           |  | QC 5 - 22             |        |
|                                     |        |         |           |  | QC 5 - 24             |        |
|                                     |        |         |           |  | QC 5 - 3              |        |
|                                     |        |         |           |  | QC 5 - 43             | DAS 43 |
|                                     |        |         |           |  | QC 5 - 49             | 9-89   |
|                                     |        |         |           |  | QC 5 - 51             |        |
|                                     |        |         |           |  | QC 5 - 58             |        |
|                                     |        |         |           |  | QC 5 - 68             |        |
|                                     |        |         |           |  | QC 5 - 9              |        |
|                                     |        |         |           |  | QC 5 - 50             |        |
|                                     |        |         |           |  | QC 5 - 30             |        |
|                                     |        |         |           |  | QC 5 - 40             |        |
| 150 Powdercoat - 4 Black Sand - B4B | 12 pcs | 4/26/19 | 0.00 0.45 |  | Powdercoat - 1 - B4B  |        |
|                                     |        |         |           |  | Powdercoat - 2 - B4B  |        |
|                                     |        |         |           |  | Powdercoat - 3 - B4B  |        |
|                                     |        |         |           |  | Powdercoat - 4 - B4B  |        |
| 160 QC 3                            | 12 pcs | 4/26/19 | 0.00 0.00 |  | QC 3 - 10             |        |
|                                     |        |         |           |  | QC 3 - 13             |        |
|                                     |        |         |           |  | QC 3 - 15             |        |
|                                     |        |         |           |  | QC 3 - 17             |        |
|                                     |        |         |           |  | QC 3 - 18             |        |
|                                     |        |         |           |  | QC 3 - 2              |        |
|                                     |        |         |           |  | QC 3 - 28             |        |
|                                     |        |         |           |  | QC 3 - 3              |        |
|                                     |        |         |           |  | QC 3 - 30             |        |
|                                     |        |         |           |  | QC 3 - 34             |        |
|                                     |        |         |           |  | QC 3 - 36             |        |
|                                     |        |         |           |  | QC 3 - 41             |        |
|                                     |        |         |           |  | QC 3 - 51             |        |
|                                     |        |         |           |  | QC 3 - 58             |        |
|                                     |        |         |           |  | QC 3 - 59             |        |
|                                     |        |         |           |  | QC 3 - 68             |        |
|                                     |        |         |           |  | QC 3 - 9              |        |
|                                     |        |         |           |  | QC 3 - 40             |        |
|                                     |        |         |           |  | QC 3 - 19             |        |
| 170 Packaging 3-1 - Stock - B4B     | 12 pcs | 4/26/19 | 0.00 0.00 |  | Packaging 3 - 1 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 2 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 3 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 4 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 5 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 6 - B4B |        |
|                                     |        |         |           |  | Packaging 3 - 7 - B4B |        |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         |                        |                 |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|-----|---------|------------------------|-----------------|
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 8 - B4B  |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 9 - B4B  |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 10 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 11 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 12 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 13 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 14 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 15 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 16 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 17 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 18 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 19 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 20 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 21 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 22 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 23 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 24 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 25 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 26 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 27 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 28 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 29 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 30 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 31 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 32 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 33 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 34 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 35 - B4B |                 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         | Packaging 3 - 36 - B4B |                 |
| 180                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | QC 21 - SA | 12  | 4/26/19 | 0.00 0.00              | QC 21 - SA - 21 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            | pcs |         |                        | QC 21 - SA - 70 |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |            |     |         |                        | QC 21 - SA - 53 |
| Part Op <b>100</b> - (Fabricate per Drwg) 1-Cut to length as per Dwg D2530<br>Descriptions: <b>110</b> - (QC5- Inspect part completeness to step on W/O)<br><b>120</b> - 1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301<br><b>130</b> - (QC9- Inspect visual per QSI004- Fusion Welds)<br><b>140</b> - (QC5- Inspect part completeness to step on W/O)<br><b>150</b> - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ FINISH TIME: _____ |            |     |         |                        |                 |



#0096 FS

- 160 - (QC3- Inspect Part Finish)  
 170 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
 180 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item      | Component Name              | Quantity              | Operation                          | Container          |
|------------------|-----------------------------|-----------------------|------------------------------------|--------------------|
| M304TR0.750W.049 | 304 Round Tube .750 X .049W | 34.3800 ft (2.865 ea) | 100-Large Fab - Welded Assy-1      | S163766 X 17.19 FT |
| D2534            | Lock Plate                  | 24 pcs (2 ea)         | 120-Large Fab - Welded Assy-2- B4B | S133774 X 17.19 FT |

S172493 X10

S155155 X14

## Job Allocations

| Operation                          | Component Part   | Required | Inventory | Allocated |
|------------------------------------|------------------|----------|-----------|-----------|
| 100-Large Fab - Welded Assy-1      | M304TR0.750W.049 | 34       | 293       | 0         |
| 120-Large Fab - Welded Assy-2- B4B | D2534            | 24       | 35        | 0         |

## Part Specifications

Specifications could not be found.

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Container No: S179138



Part: D2530

Job No: 191808

Serial No/Batch: S179138

Revision:

Inspector:

Exp Date:

Instructions: Various QC's

Date: 05/08/19

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Sequence #: _____                                                                                                                 | QTY Affected : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |